



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

4.5NR-34
Job Sheet 190284



Part No: 4.5NR-34

Job Qty: 12 pcs

Part Name: Load Rails



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 3/5/19 *March*

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG 4.5NR-34 Rev.4 IPP Rev. A 19.02.06 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Waterjet - Omax - 1	12 pcs	3/5/19	3/5/19	0.00	0.80	Waterjet - Omax	<i>ac 19/02/19</i>
100	NV5000 - 1 - B4B	12 pcs	3/5/19	3/5/19	0.00	12.00	NV5000 - 1 - B4B	
							NV5000 - 2 - B4B	<i>J.C.V.</i>
120	QC 2	12 pcs	3/5/19	3/5/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	<i>J.C.V. 19-02-20</i>
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	



Container No: S154004



Part: 4.5NR-34

Job No: 190284

Serial No/Batch: S154004

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
130 QC 8	12 pcs	3/5/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	A. 19-02-23
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
135 Outsource - 1 - Heat Treat	12 pcs	3/5/19	MAR 13 2019	MEI001-VC	10
140 Outsource - 15 - Nickel Plate	12 pcs	3/5/19		GRO002-VC	10
150 Packaging 2-1 - Receive - B4B	12 pcs	3/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	

160 QC 6	12 pcs	3/5/19	0.00 0.00	Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
					DAS
					MAR 2 1 2019 68
					9-89
210 Packaging 3-1 - Stock - B4B	12 pcs	3/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	3/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 90 - Cut blanks.
 Descriptions: 100 - 1-Machine as per folio FC 658 FOLIO REV: _____ DWG REV: _____ 2-Debur
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 135 - 1-Issue; P/O _____ RC; 40-45 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required
 NOTE DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH***
 140 - (Outside Processing - Nickel Plate) -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC6- All purchased or subcontracted products)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.375	AISI 4140 Steel Sheet cut to size" 4ft x 4 ft	.6240 sf (.052 ea)	90-Waterjet - Omax - 1	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Waterjet - Omax - 1	MT-4140-S-0.375	1	32	0
Part Specifications				
Specifications could not be found.				

Plex 2/6/19 2:54 PM dart.lacelle.linda



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Container No: S154004



Part: 4.5NR-34

Job No: 190284

Serial No/Batch: S154004

Revision: 4

Inspector:

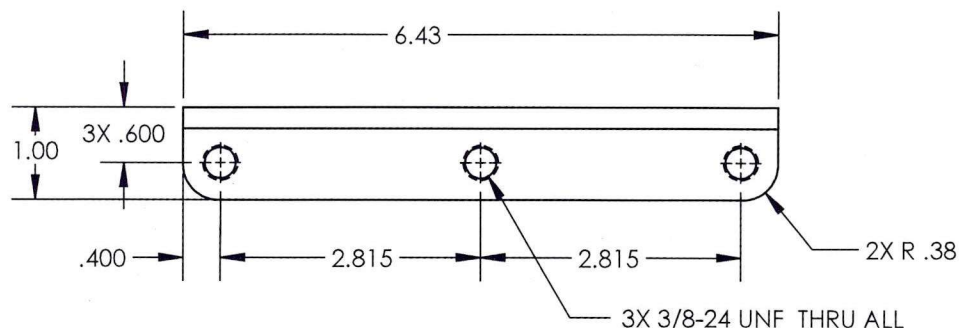
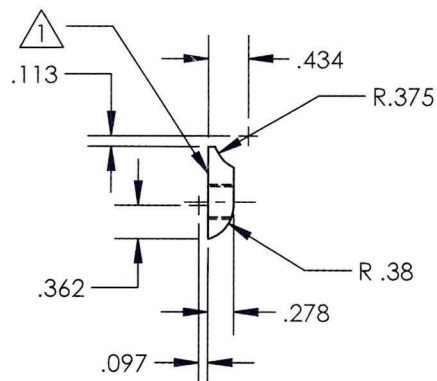
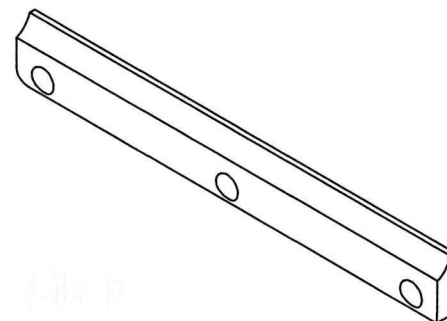
Exp Date:

Instructions:

Date: 02/14/19

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	7/22/2013	JAG	
3		CH'D FINISH WAS YELLOW ZINC IS NICKEL PLATE AND BAKE.	9/13/2013	CFS	RW
4	14-0094	CH'D TITLEBLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE.	7/29/2014	DJN	RW



NOTES:

- 1 MACHINE ENGRAVE BATCH NUMBER.
2. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE LOAD RAIL	
DWG NO. 4.5NR-34	REV 4
MAT'L 4140/4142	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	APPROVED <i>D Weir</i>
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT HRC 40-45
	FINISH SEE NOTE 2
	SPEC
	USED ON MODEL
SCALE 1:2	DATE 10/9/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			4.5NR-34	1	LOAD RAIL	4140/4142	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042718



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO042718

PO Date: 2/26/19

Due Date: 3/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190284	4.5NR-34	Load Rails 1-Issue; P/O _____ RC; 40-45 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH***	Firmed	-	3/20/19	12 pcs	0 pcs	12 pcs	\$25.833333300/pcs	\$310.00

12 x MAR 13 2019

DAS
68
9-89

Grand Total: \$310.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
334498	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

GROUP ALTECH

2455 ALPERN

ST LAURENT

1

QC H4S1N9

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42718	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	40 - 45 HRC	12 (907)	44 - 45 HRC	60 9-80
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
12	5	4.5NR-34 (12) 4.5NR-34 JOB 190284 1 BOITE DE CARTON		

COMMENTAIRES / comments

SALT HARDEN 1550F 40 MINS

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042877



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042877
PO Date: 3/13/19
Due Date: 3/20/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190284	4.5NR-34	Load Rails (Outside Processing - Nickel Plate) -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	3/20/19	12 pcs	0 pcs	12 pcs	\$20.00/pcs	\$240.00
Grand Total:											\$240.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

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Plex 3/13/19 2:58 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(017600-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017600- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
15-Mar-2019		Jessie Boisvert			042877 ✓			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	4.5NR-34 Rev. ✓	4.5NR-34 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 BAKE AFTER PLATING	E-NICKEL STEEL CH	12	12 ✓	0	0	DAS 68 9-89

Notes Additionnelles / Additional Notes

Box

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.